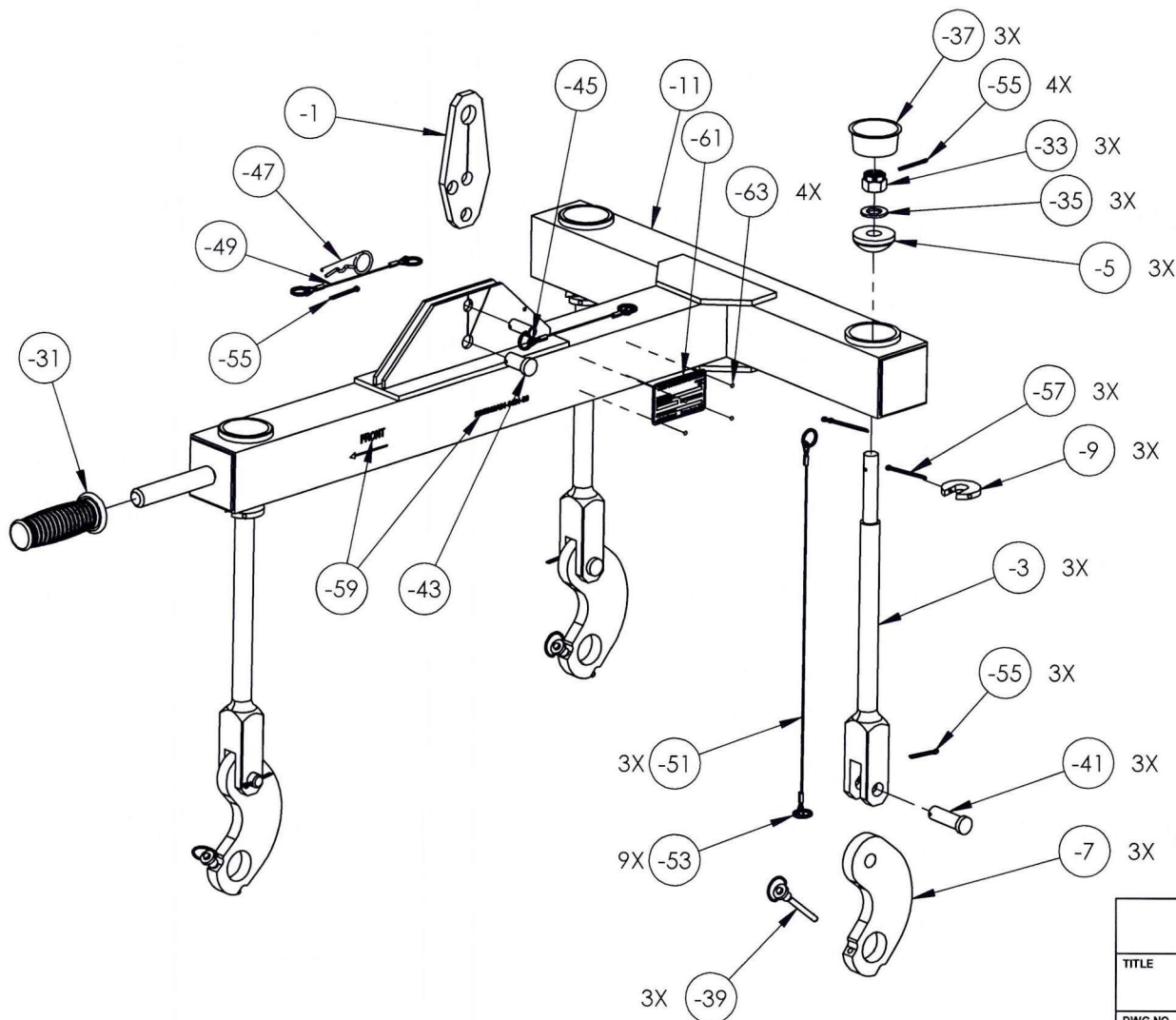


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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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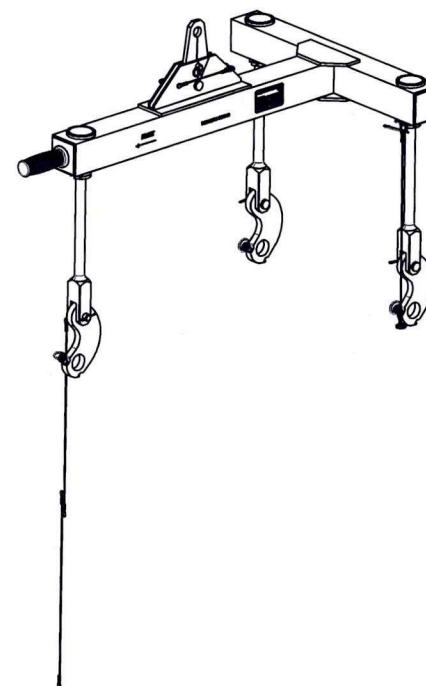
ECN 19-761



RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: GILBERT APPROVED: VP HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:8	DATE 2011-04-21
SHEET 1 OF 19	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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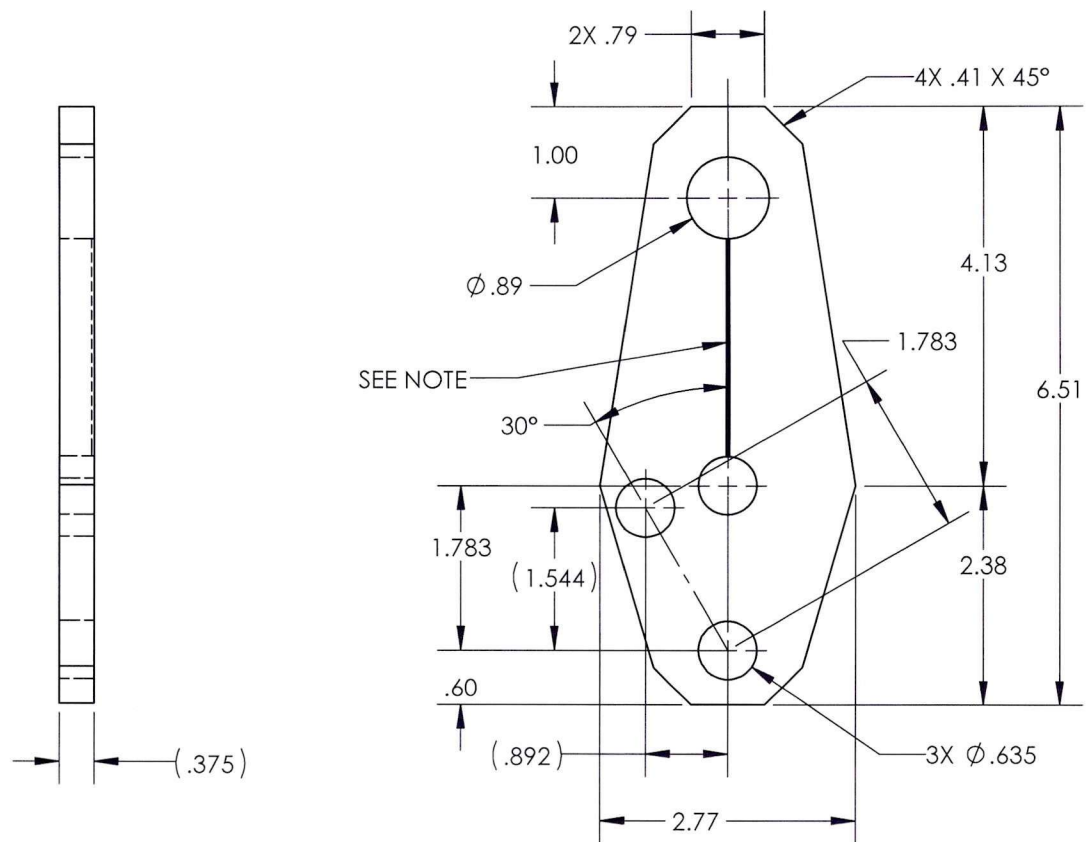


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	LIFTING EYE	A36PO	3/8 X 2-7/8 X 6-3/4	3
			-3	3	CONNECTOR ROD	1018	Ø2 X 17	4
			-5	3	BUTTON	BRONZE	Ø2 X 1	5
			-7	3	CONNECTOR HOOK	A36PO	5/8 X 5-1/2 X 5-3/4	6
			-9	3	STOP DISK	A36PO	1/4 X 2 X 2	7
	X		-11	1	WELDMENT			8
1			-13		MAIN TUBE	CARBON STEEL	3 X 3 X 3/16 WALL X 30-1/4	9
1			-15		CROSS TUBE	CARBON STEEL	3 X 3 X 3/16 WALL X 23-1/2	10
2			-17		GUSSET	A36PO	1/4 X 6-1/2 X 3-1/4	11
3			-19		TUBE CAP	A36PO	1/8 X 3 X 3	
1			-21		MOUNT PLATE	A36PO	1/4 X 3-1/4 X 10-1/2	13
2			-23		PIVOT PLATE	A36PO	3/16 X 3-1/2 X 10-1/2	14
1			-25		ROD	1018	Ø7/8 x 4-3/4	15
3			-27		PIVOT TUBE	1018	Ø2-1/2 X 3-1/2	16
		B/O	-31	1	GRIP	PVC	FLANGED Ø7/8 MCMaster-CARR #97045K23	1
		B/O	-33	3	CASTLE NUT	STEEL	M16 X 2 MCMaster-CARR #93760A328	1
		B/O	-35	3	FLAT WASHER	STEEL	M16 MCMaster-CARR #91166A310	1
		B/O	-37	3	PLUG	PLASTIC	PLUG MCMaster-CARR #4491K26	1
		B/O	-39	3	BALL LOCK PIN	STAINLESS STEEL	1/4 X 2 MCMaster-CARR #92384A038	1
		B/O	-41	3	PIN	STEEL	5/8 X 2 MCMaster-CARR #97245A455	1
		B/O	-43	1	PIN	STEEL	5/8 X 1-1/4 MCMaster-CARR #98306A491	1
		B/O	-45	1	PIN	STEEL	1/2 X 1-13/32 MCMaster-CARR #93890A473	1
		B/O	-47	1	DOUBLE LOOP CLIP	STEEL	G.L. HUYETT #BPD-0118	1
		B/O	-49	2	LANYARD	S.S.	6" LOOP/LOOP MCMaster-CARR #90312A150	1
		B/O	-51	3	LANYARD	S.S.	18" LOOP/LOOP MCMaster-CARR #90312A360	1
		B/O	-53	9	SPLIT RING	STEEL	7/8 MCMaster-CARR #90177A217	1
		B/O	-55	7	COTTER PIN	STEEL	1/8 X 1-1/2 MCMaster-CARR #98338A190	1
		B/O	-57	3	COTTER PIN	STEEL	1/8 X 2 MCMaster-CARR #98338A200	1
		B/O	-59	2	LABEL	VINYL	SIGNS NOW	17
		B/O	-61	1	RED BARN PLACARD	ALUMINUM	RB41009	18
		B/O	-63	4	#2 DRIVE SCREW	COATED STEEL		1
ASSY -11								

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: GILBERT APPROVED:  HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:16	DATE 2011-04-21
SHEET 2 OF 19	

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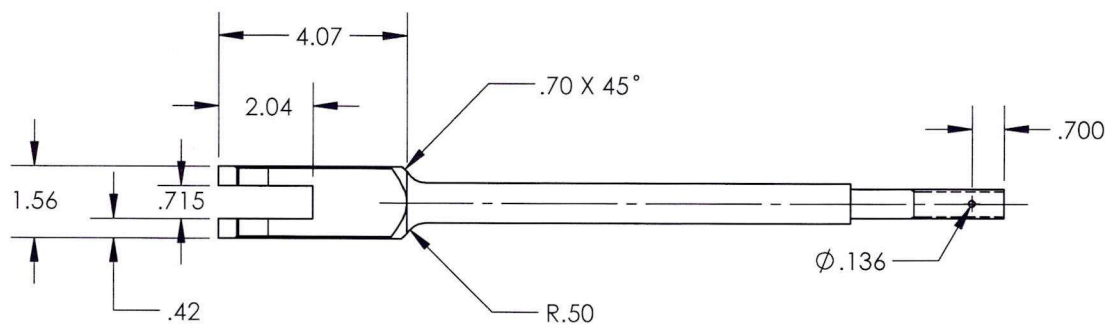
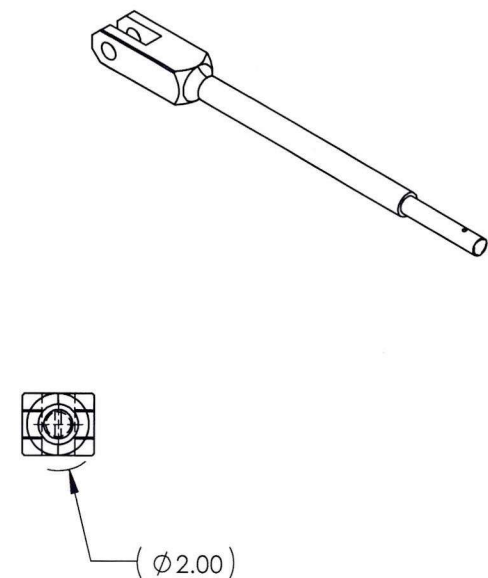
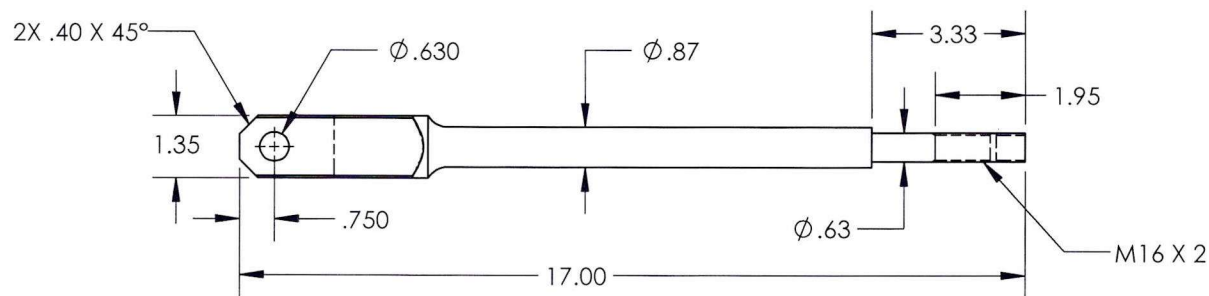
NOTE: .03 DEEP GROOVE AS SHOWN, THIS SIDE ONLY , TO BE INKED AFTER POWDER COAT.

(-1)
LIFTING EYE

RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-1	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH: POWDER COAT YELLOW SPEC: FED #13538 USED ON MODEL EUROPTER
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE: 1:2 DATE: 2011-04-21 SHEET 3 OF 19

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
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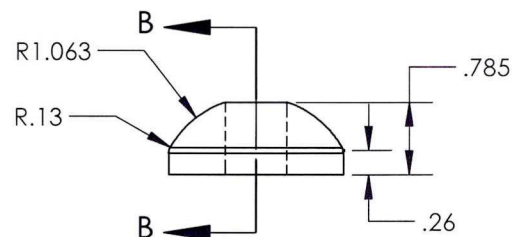
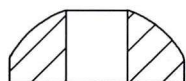
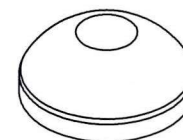
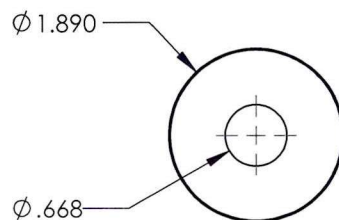
(-3)

CONNECTOR ROD

RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-3	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 2011-04-21
SHEET 4 OF 19	
DRAWN BY: GILBERT	
APPROVED <i>D Weil</i>	
HEAT TREAT FINISH POWDER COAT YELLOW	
SPEC FED #13538	
USED ON MODEL EUROCOPTER	


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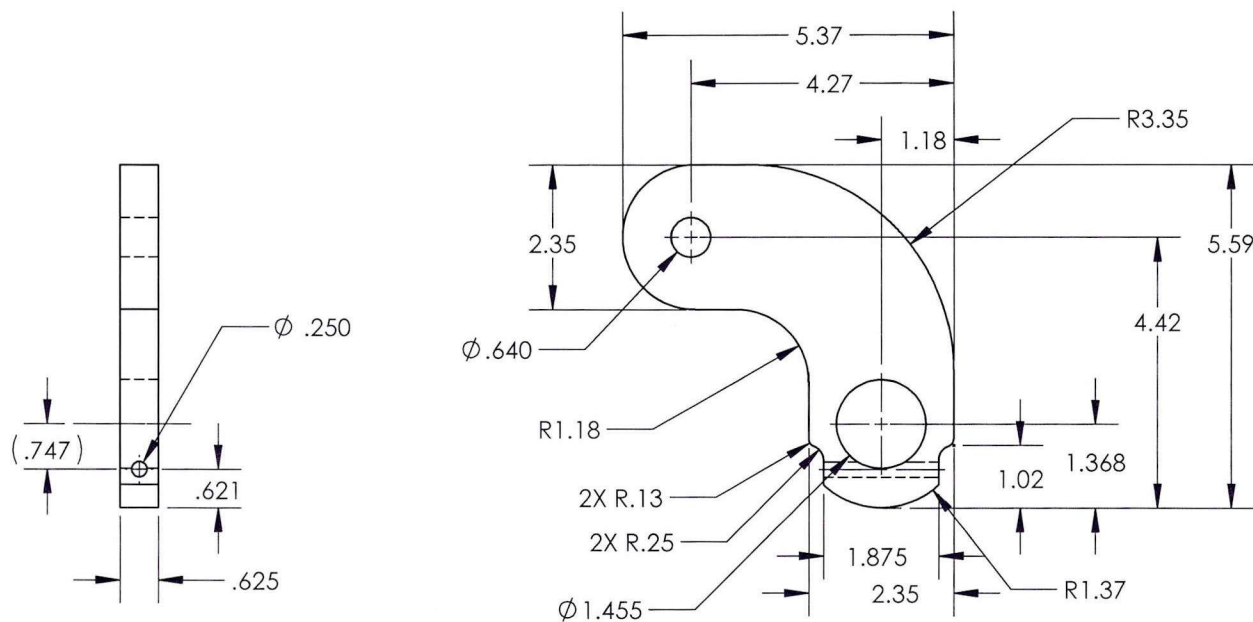
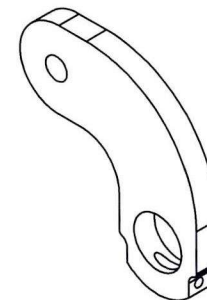
SECTION B-B

(-5)
BUTTON

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-5	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:2	DATE 2011-04-21 SHEET 5 OF 19

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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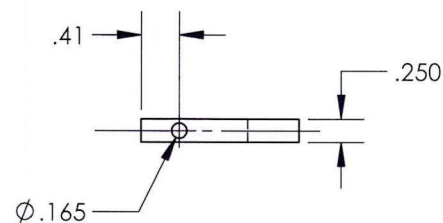
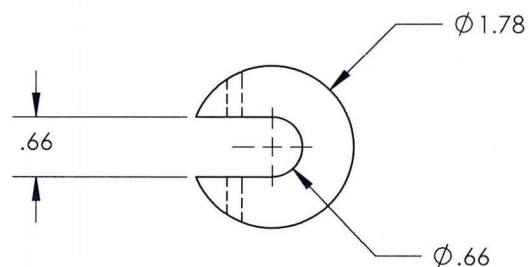
(-7)

CONNECTOR HOOK

RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-7	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS .XXX $\pm .005$	FRACTIONS $\pm 1/32$
.XX $\pm .01$	ANGLES $\pm .5^\circ$
.X $\pm .1$	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:3	DATE 2011-04-21
DRAWN BY: GILBERT	
APPROVED <i>D Weid</i>	
HEAT TREAT FINISH POWDER COAT YELLOW	
SPEC FED #13538	
USED ON MODEL EUROCOPTER	
SHEET 6 OF 19	

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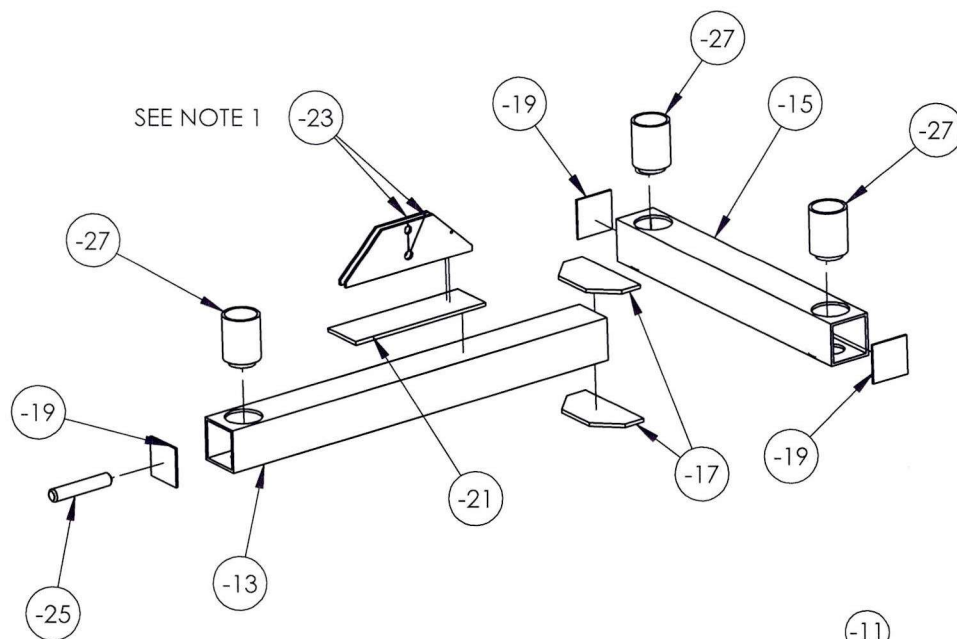
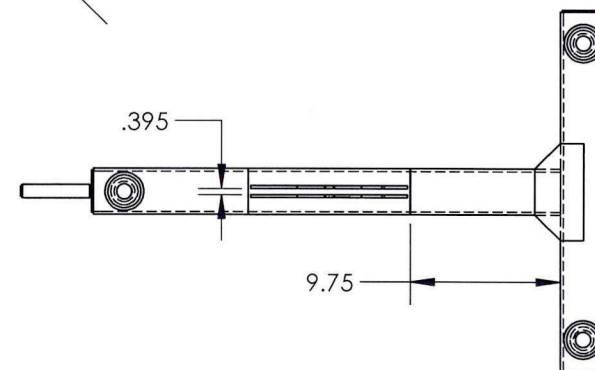
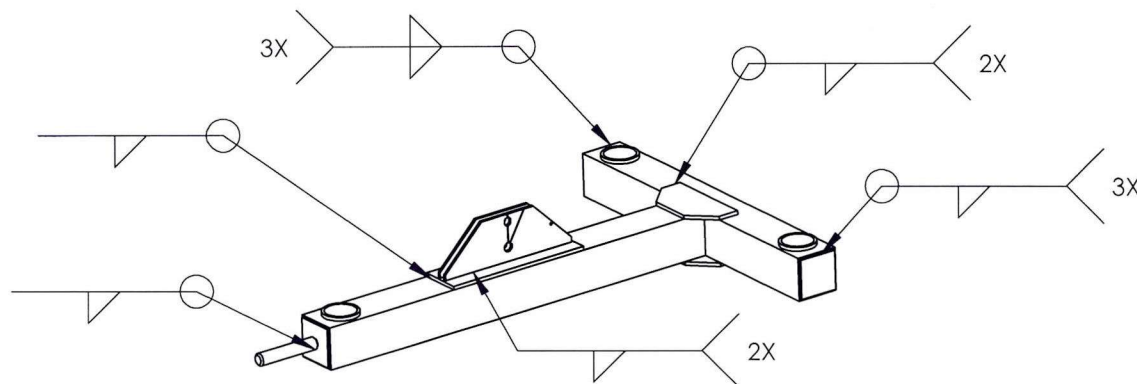
(9)

STOP DISK

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-9	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538 USED ON MODEL EUROCOPTER
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE 1:2 DATE 2011-04-21 SHEET 7 OF 19

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SEE NOTE 1

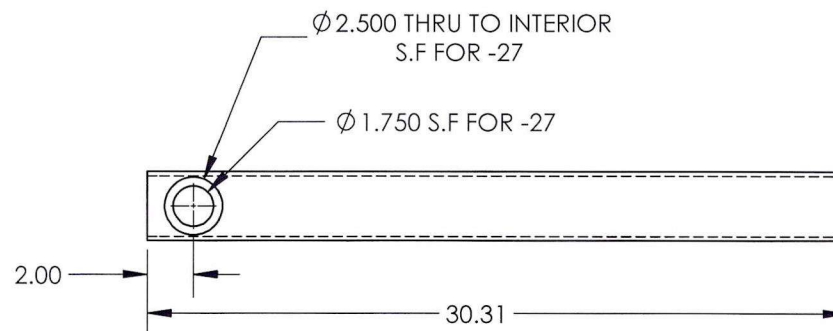
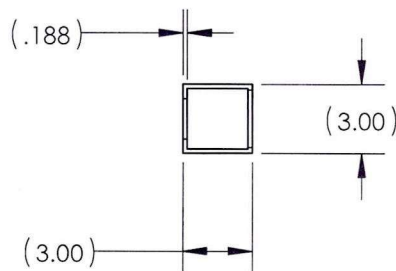
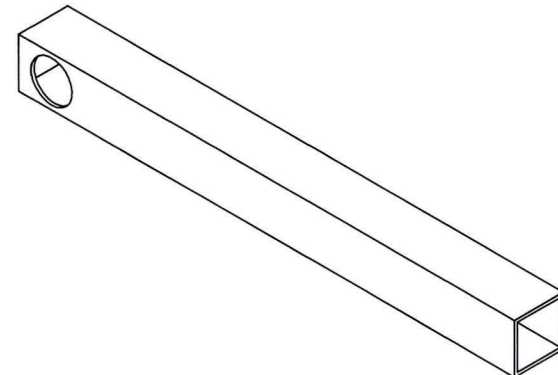
- NOTE: 1. WELD ITEMS 23 IN PLACE WITH GROOVED
PIECE TO OUTSIDE AS SHOWN
2. WELD ALL SEAMS 100%.
3. REMOVE ALL WELD SPLATTER.

WELDMENT

RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-11	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:12	DATE 2011-04-21
SHEET 8 OF 19	

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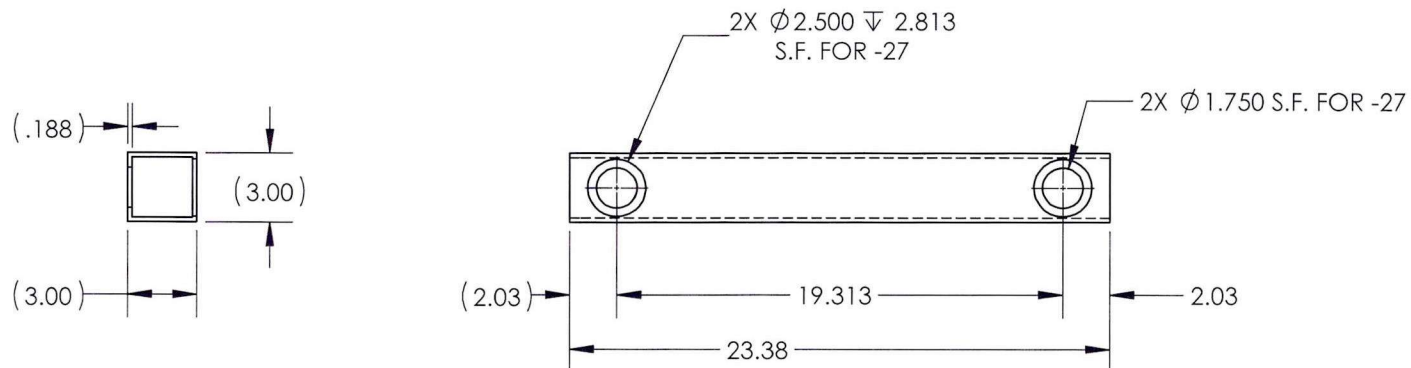
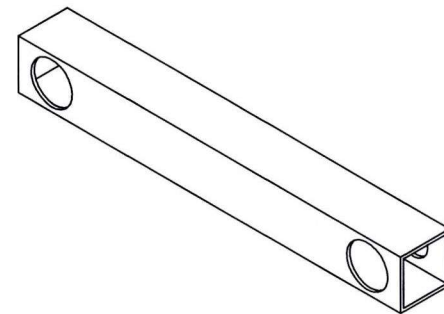
(-13)

MAIN TUBE

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-13	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:8	DATE 2011-04-21 SHEET 9 OF 19

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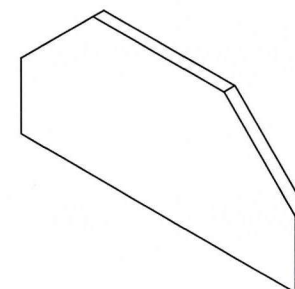
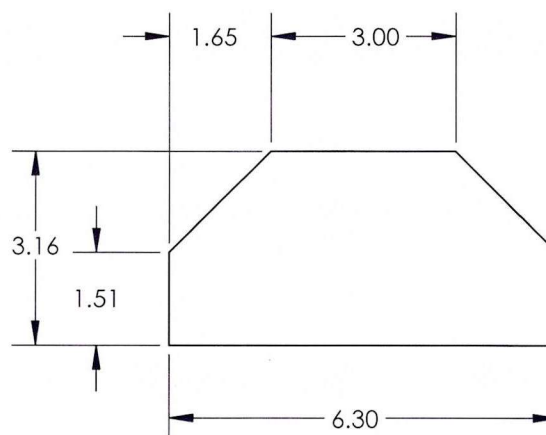
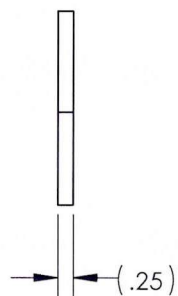
(-15)

CROSS TUBE

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-15	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS $\pm 1/32$
.XXX $\pm .005$	ANGLES $\pm .5^\circ$
.XX $\pm .01$	
.X $\pm .1$	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: GILBERT	
APPROVED <i>D Weil</i>	
SPEC	
USED ON MODEL	
EUROCOPTER	
SCALE 1:8	DATE 2011-04-21
SHEET 10 OF 19	

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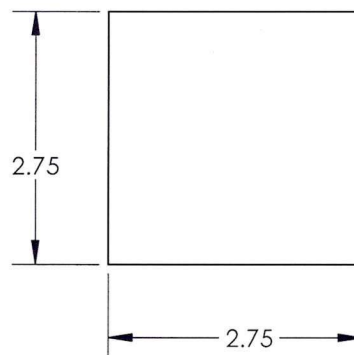
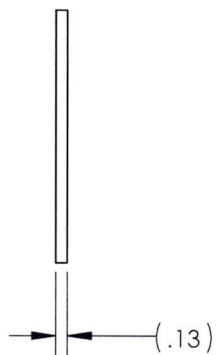
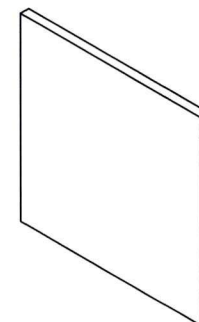


(-17)
GUSSET

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-17	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL EUROCOPTER
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:3	DATE 2011-04-21 SHEET 11 OF 19


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REVISIONS				
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A	NEW ISSUE	2019-06-03		VM



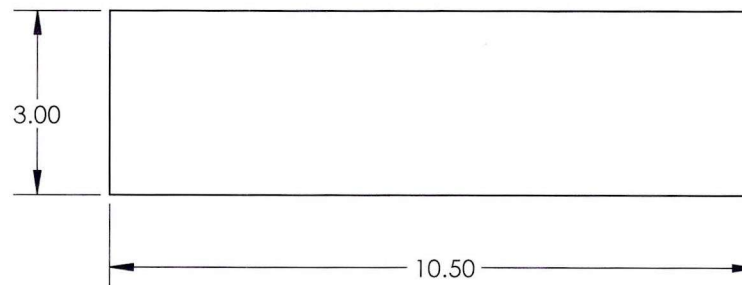
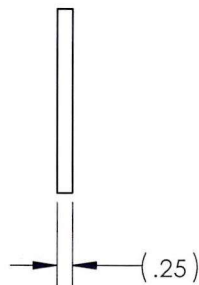
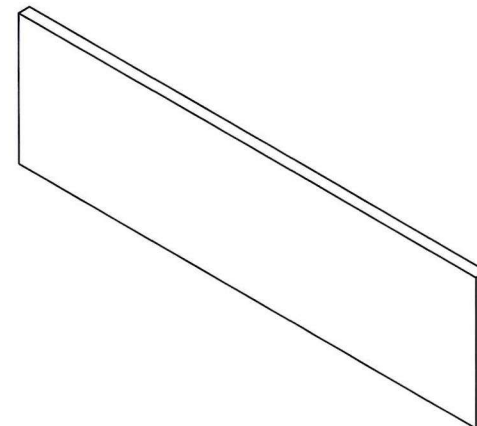
-19

TUBE CAP

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-19	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:2	DATE 2011-04-21
SHEET 12 OF 19	

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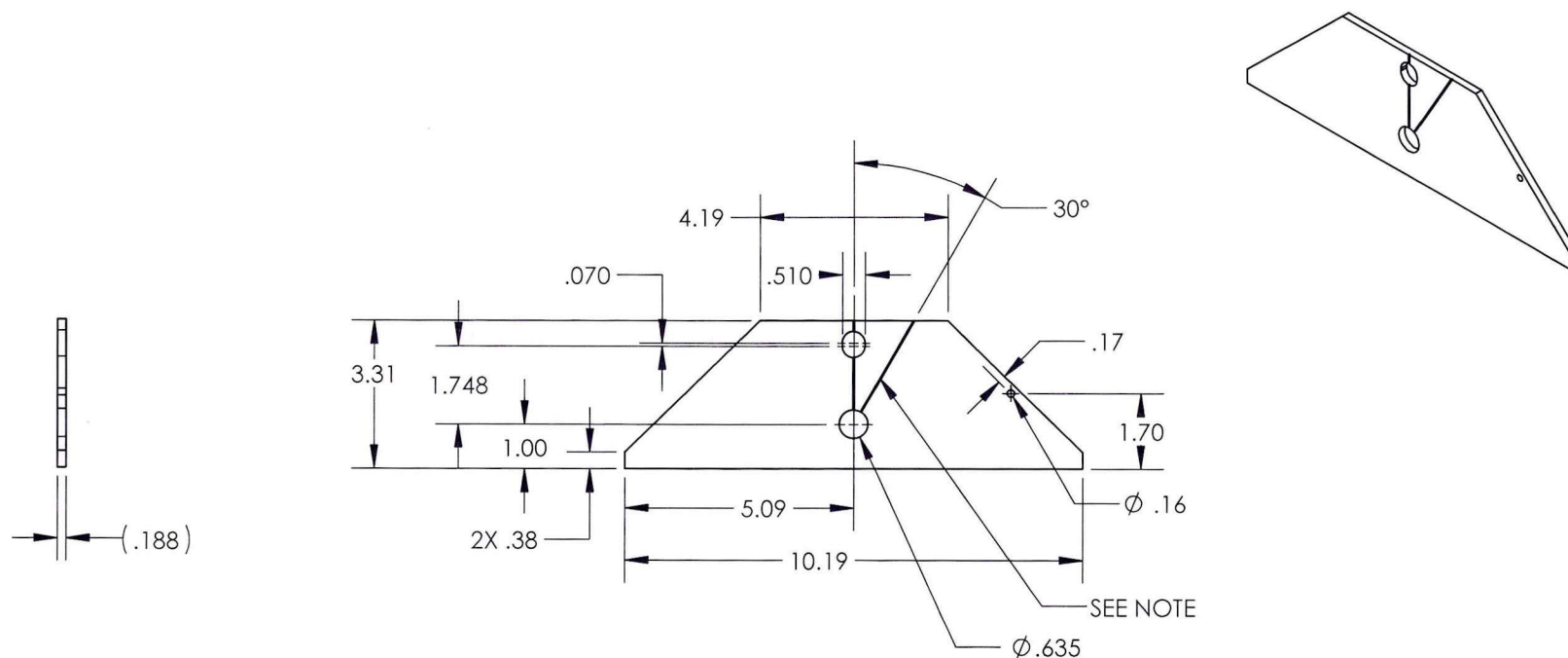
(-21)

MOUNT PLATE

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-21	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	
DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL EUROCOPTER	
SCALE 1:3	DATE 2011-04-21 SHEET 13 OF 19

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NOTE: .03 DEEP GROOVE AS SHOWN, THIS SIDE ONLY, TO BE INKED AFTER POWDER COAT. GROOVE 1 OF 2 NEEDED PER ASSY.

(23)

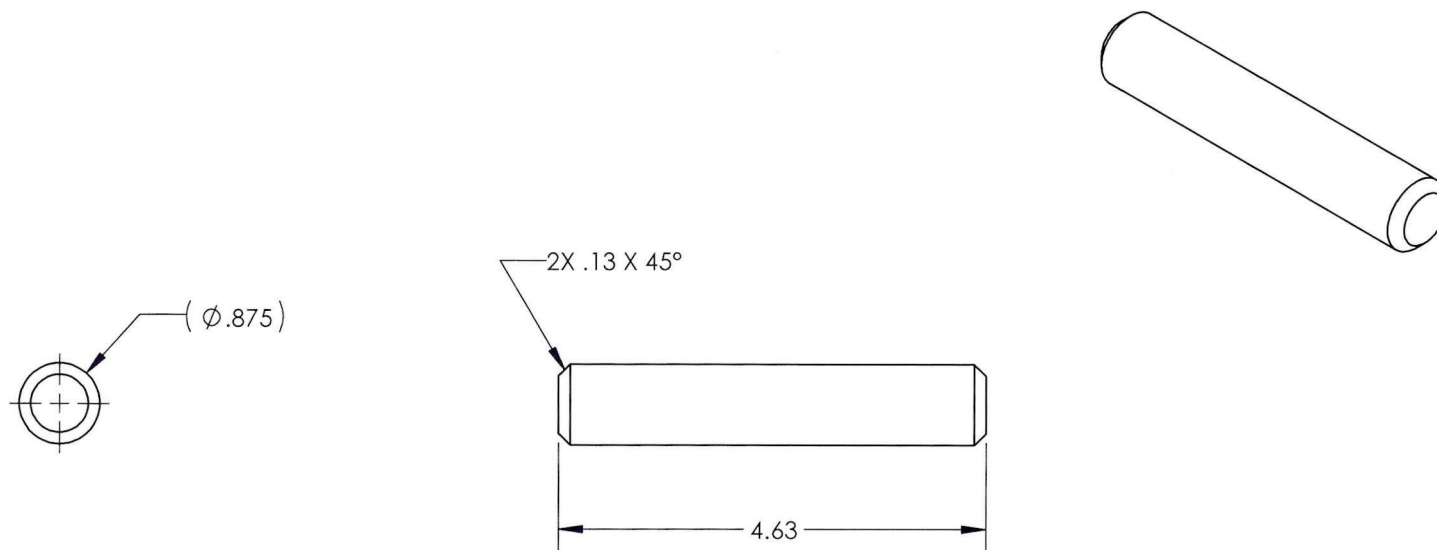
PIVOT PLATE

RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-23	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 2011-04-21
SHEET 14 OF 19	


DRAWN BY: GILBERT
APPROVED <i>D Weil</i>
HEAT TREAT FINISH
SPEC
USED ON MODEL EUROCOPTER

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	NEW ISSUE	2019-06-03		VM

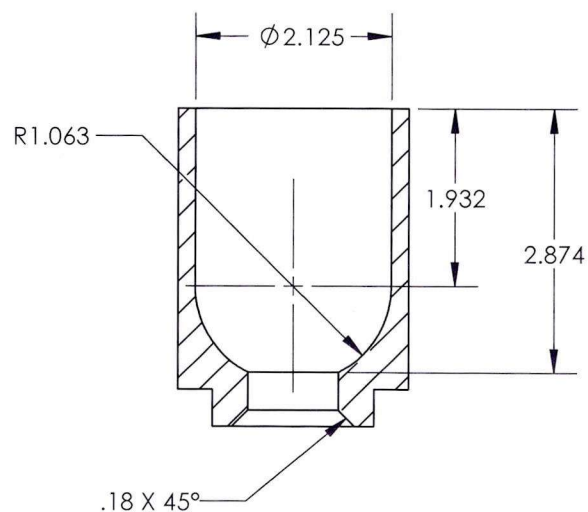
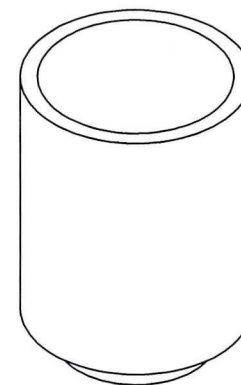
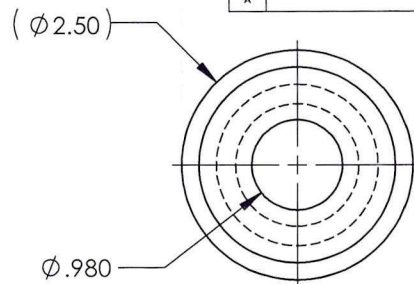


(-25)
ROD

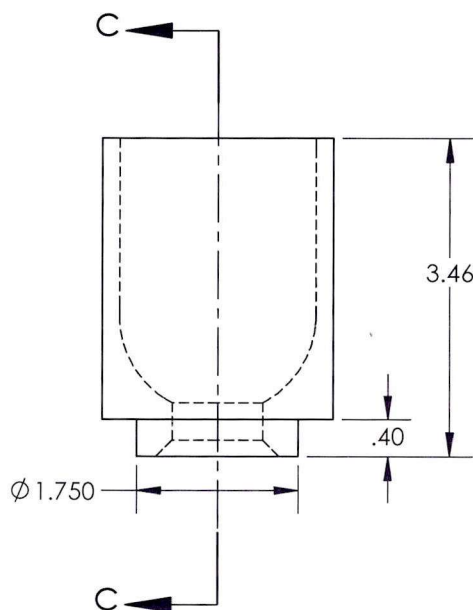
 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-25	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH: SPEC:	
USED ON MODEL: EUROCOPTER	
SCALE 1:2	DATE 2011-04-21
SHEET 15 OF 19	

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SECTION C-C



(-27)

PIVOT TUBE

RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-27	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:2	DATE 2011-04-21 SHEET 16 OF 19

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A	NEW ISSUE	2019-06-03		VM

A- FRONT .38

Handwritten: 2019-06-19

B- 2.32 .30

C- RBE332A91-3191-00 .25

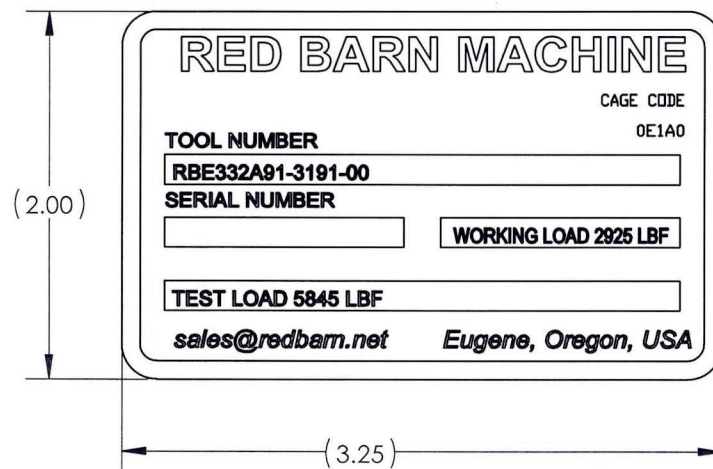
NOTE: BLACK LETTERS, ADHESIVE BACK, ARIAL FONT

(-59)
LABEL


RB RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-59	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS .XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± .5°
.X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 2011-04-21
SHEET 17 OF 19	
DRAWN BY: GILBERT	
APPROVED <i>D. Weil</i>	
HEAT	
TREAT	
FINISH	
SPEC	
USED ON MODEL	
EUROCOPTER	

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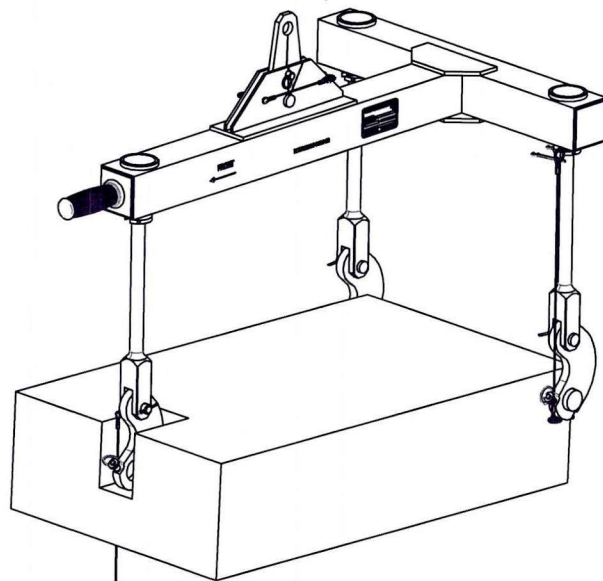
NOTE: ENGRAVE AS SHOWN

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00-61	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL EUROCOPTER
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 2011-04-21
SHEET 18 OF 19	

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FIRST ARTICLE WEIGHT TEST



INSPECTION & TESTING PROCEDURES FOR THE RBE332A91-3191-00, SLING, M/R HEAD 5 BLADE. THIS ASSEMBLY IS DESIGNED EXCLUSIVELY FOR HOISTING AND INSTALLING/REMOVING THE 5-BLADED MAIN ROTOR HEAD. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON A OVERHEAD LIFTING DEVICE. ATTACH 3 CONNECTOR HOOKS TO AN APPROAPITE TEST WEIGHT OF 5845 LBS, USE BALL LOCK PINS TO LOCK INTO FIXTURE.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR _____

TESTER _____

S.N. _____

DATE _____

 RED BARN MACHINE	
TITLE SLING, M/R HEAD 5 BLADE	
DWG NO. RBE332A91-3191-00	REV A